Work Order ID 62711 -2

Wednesday, October 06, 2010 3:39:28 PM

Item ID: D4154-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearplate Assembly

Start Date: 10/6/2010 **Start Qty:** ~~10.00~~ 4

Required Date: 10/15/2010 **Req'd Qty:** ~~10.00~~

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** M Date: 10-6-10 **Tooling:** Date:

QC: Date: **SPC (Y/N):** Date:

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4154	A								
100		0.00							
Large Fab									
Large Fab	**Memo**	0.00							

EL ~~10-12-22~~ x1

EL 11-1-4 x4

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154
2059 B Hardcoat Welding Rod
BATCH#: M116379

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154
304 S.S. Welding Rod
BATCH #: M101744

3-Transfer drill holes in bar

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									

CPL 11.01.04 x4

~~CPL 10.12.23~~ 1x

Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM

Item ID: D4154-041
Revision ID:
Item Name: Wearplate Assembly
Start Date: 10/6/2010 **Start Qty:** 10.00
Required Date: 10/15/2010 **Req'd Qty:** 10.00
Reference:

Accept

Setup Start

Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10 +4			
130 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 8:45 8:00 OVEN TEMPERATURE: 300 320° FINISH TIME: 9:45 8:30.	0.00 M112588 0.00				1 BR 10-12-23. 4 BR 10-01-5.			
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4			

Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM

Item ID: D4154-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearplate Assembly

Start Date: 10/6/2010 **Start Qty:** ~~10.00~~ 1 **Cust Item ID:**

Required Date: 10/15/2010 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Small Fab		0.00				ML	11	01	05 (4)
Small Fab	Memo	0.00							
M116210	1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154.					~~10/12/23~~			(1)
	~~COATED inner surface w Rockguard 4715 M116210 10/12/23~~								
160 QC	QCS- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				~~10/12/23~~			(4)
170 Packaging	Identify as per dwg & Stock Location: Finishing	0.00							
Packaging	Memo	0.00				~~10/12/23~~ (1)			
	~~CAP 6485~~								
						ML 10/01/06			

Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM

Item ID: D4154-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearplate Assembly

Start Date: 10/6/2010 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 10/15/2010 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					10/12/23		
QC Quality Control	Memo	0.00							

CK 11/01/07 AWE 10-12-23

Picklist Print

Wednesday, October 06, 2010 3:39:33 PM

Work Order ID: 62711

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly

Start Date: 10/6/2010 **Required Date:** 10/15/2010

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1 Plate		Manufactured	No			100	Each	4.0000	1	10	EL 11-1-4 EL EL		

Location	Loc Qty	Loc Code
WA	4	
62199	4	

D62708 x4

D4155-1 Bar		Manufactured	No			100	Each	5.0000	1	10	EL 11-1-4 EL EL		

Location	Loc Qty	Loc Code
ST	5	
60976	2	
62198	3	

62709 4 4

DART AEROSPACE LTD	Work Order:	6371
Description: Plate	Part Number:	D4154-1
Inspection Dwg: D4154 Rev: A		Page 1 of 1

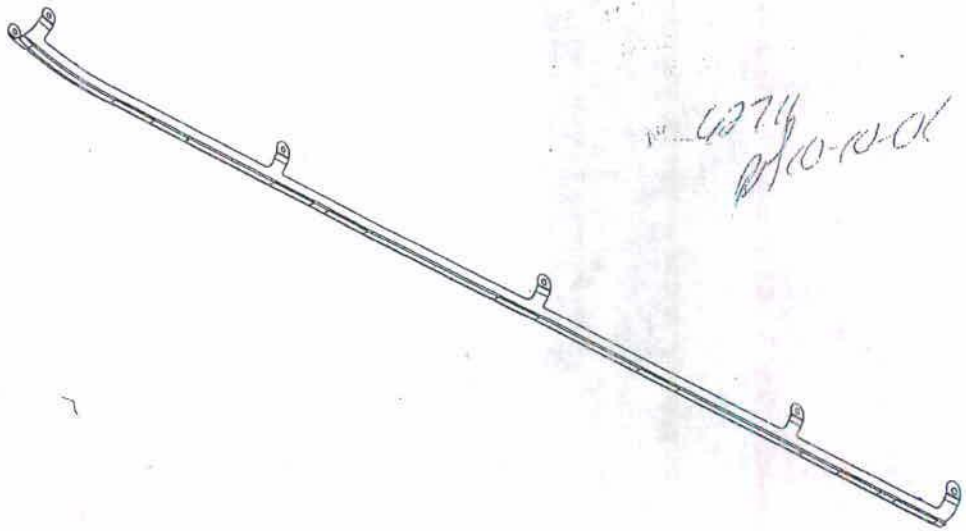
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001					
Ø0.516	+0.008/-0.001					
0.88	+/-0.030					
0.125	+/-0.010					
0.25	+/-0.030					
0.400	+/-0.010					
0.050	+/-0.010					
0.55	+/-0.030					
4.75	+/-0.030					
4.00	+/-0.030					
14.00	+/-0.030					
61.00	+/-0.030					
91.50	+/-0.030					
1.20	+/-0.030					
1.80	+/-0.030					
2.75	+/-0.030					
6.42	+/-0.030					
15.45	+/-0.030					
40.70	+/-0.030					
66.45	+/-0.030					
90.35	+/-0.030					
6.72	+/-0.030					
0.050	+/-0.010					

Measured by:		Audited by:		Preliminary Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)



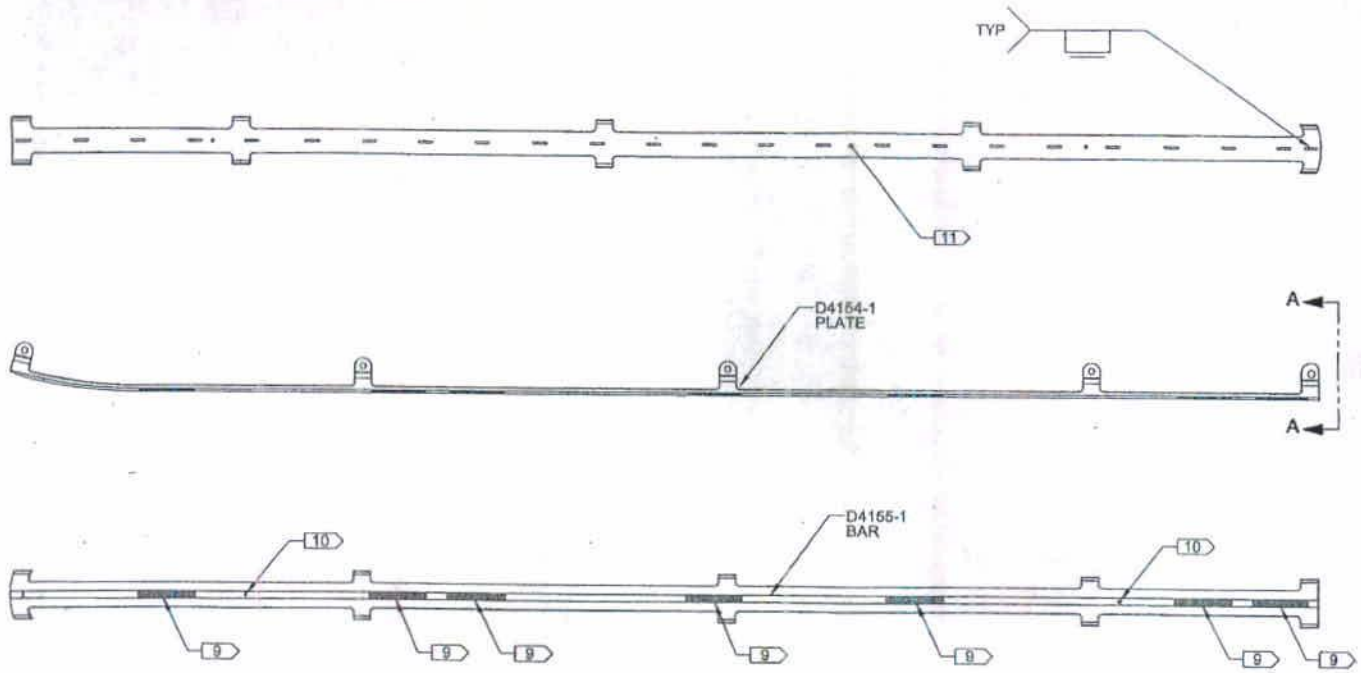
D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010 -09- 15

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	SC	10.07.22

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	SC	
CHECKED		DRAWING NO. D4154 REV. A
MFG. APPR.		SHEET 1 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	10.07.22	

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



w/o 42711

RELEASED
2010 -09- 15

D4154-041 WEARPLATE ASSEMBLY



SECTION A-A

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: 5.99 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF ~~SIKAFLEX 241/ 291 OR PROSEAL 890~~ OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

10.01.05

w/116210

PLUS 1 ROCKGUARD
4715

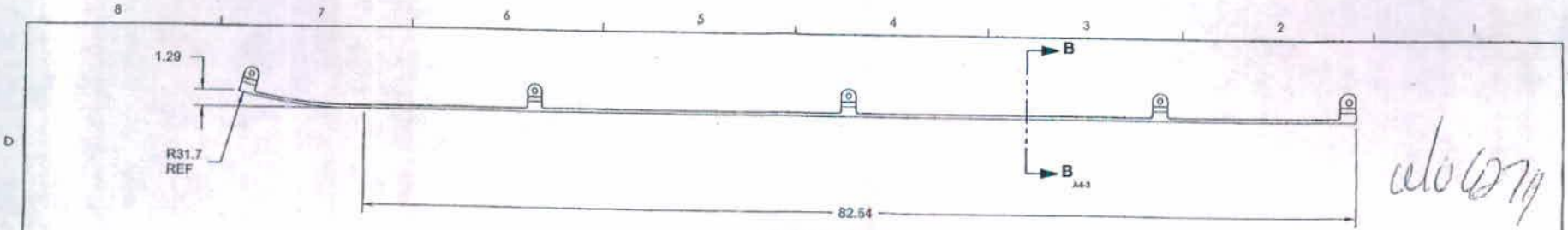
10.12.23

DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	SC	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4154 REV. A
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	10.07.22	

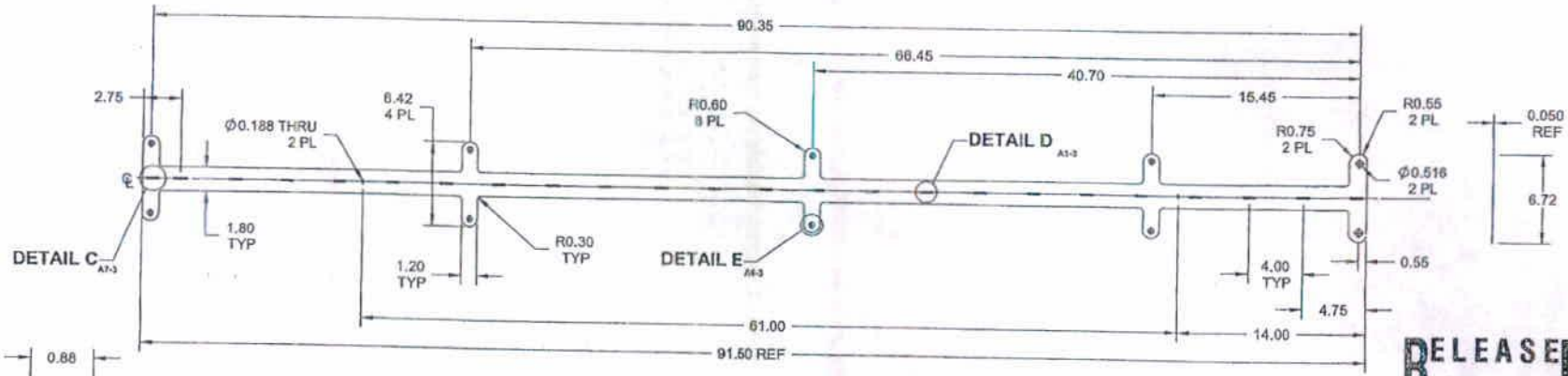
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, EITHER SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN AUTHORIZATION FROM DART AEROSPACE (KELYE).

Ref. B63871

B63330
B62196

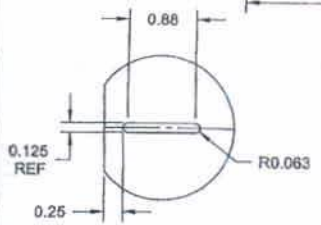


D4154-1 PLATE
(MAKE FROM D4154-1F)

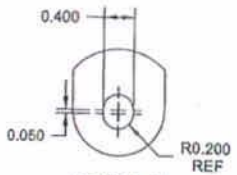


D4154-1F FLAT PATTEN

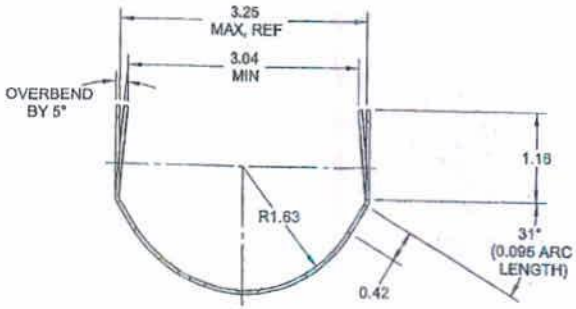
RELEASED
2010-09-15



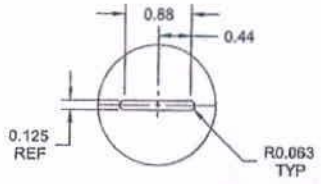
DETAIL C C7-3
SLOT DETAIL TYP



DETAIL E C4-3
SLOT DETAIL TYP



SECTION B-B D3-3



DETAIL D C4-3
SLOT DETAIL TYP

NOTES:
1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH : NONE
3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS : INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
6) IDENTIFICATION : NONE
7) WEIGHT : 2.71 lbs

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	SC	
CHECKED		DRAWING NO. D4154 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	10.07.22	

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.